

## **ABSTRACT**

5        A cold-box process for preparing a foundry shape, e.g. mold or core, that uses a  
binder comprising a phenolic resin component and an isocyanate component, wherein  
the phenolic resin component comprises (a) an alkoxy-modified phenolic resole resin  
and (b) an oxygen-rich polar, organic solvent component, which contains a fatty acid  
ester.

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